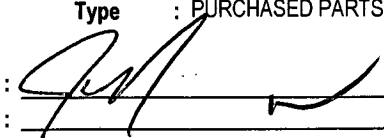


Date: Monday, 7/31/2006 12:49:02 PM
User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT CAP
Job Number	: 28041		
Estimate Number	: 10312		
P.O. Number	:	Part Number	: D2646
This Issue	: 7/31/2006 S.O. No. :	Drawing Number	: D2646 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: B
Previous Run	: 25381	Material	:
Written By	: 	Due Date	: 8/15/2006
Checked & Approved By	:	Qty:	100
Comment	: Est: G 05.08.22 Hole size revised in Step 5 KJ/JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: 1759

0206/08/01



1-Spin as per Dwg D2646

2-Material release note required

2.0	D2646P	Aft Cap
-----	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

AFT CAP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D2646

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill using DT8026 as per Dwg D2646.


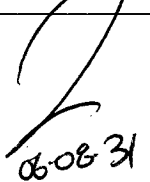
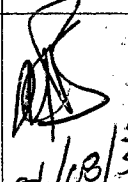
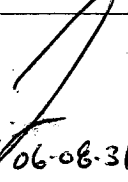

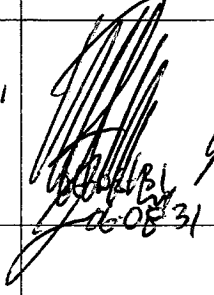

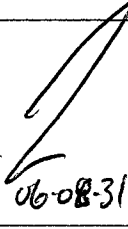
2-Open holes to .250" and c'sink as per Dwg D2646.

3-Deburr

FF 06.08.24 100



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-08-31	5-0	During c'sinking for NAS 1330C → 3KD116 inserts, the hole become oversized by .030 → .040. NAS insert is loose in the holes. HUMAN error, risky c'sink on such thin, round material.		Drill hole open to .297, and deburr as necessary. Insert 2x ALS4-1032-130 inserts as per Dwg 2646 Rev. A.	FT 06-08-31	 06-08-31	 06/08/31	 06-08-31
06-08-31	5-	1 part scrap. Used for Insert test fit : strength.	 06-08-31	The insert passed, but the cap is no more good. destroy.	CL 06/08/31	 06-08-31	 06-08-31	 06-08-31

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/08/05

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 7/31/2006 12:49:02 PM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CAP

Job Number: 28041

Part Number: D2646

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Q.M.

06-09-01

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Q.M.

06-09-01

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL

06/08/02

9.0

~~NAS1330C3KB116~~

Insert



Comment: Qty.: 2.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick: *ALS 4-1032-130*

check inv.

Qty

Part Number

Description

Batch

2

~~NAS1330C3KB116~~

Insert

M19393

or AESS10KB116

DL

06/09/03

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install inserts as per Dwg D2646

DL 06/08/03

(1)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

M

06 09 03

(1)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *N/A*

DL

06/09/05

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 7/31/2006 12:49:02 PM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CAP

Job Number: 28041

Part Number: D2646

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

705

04/09/05

Job Completion



u 06-09-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector



NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

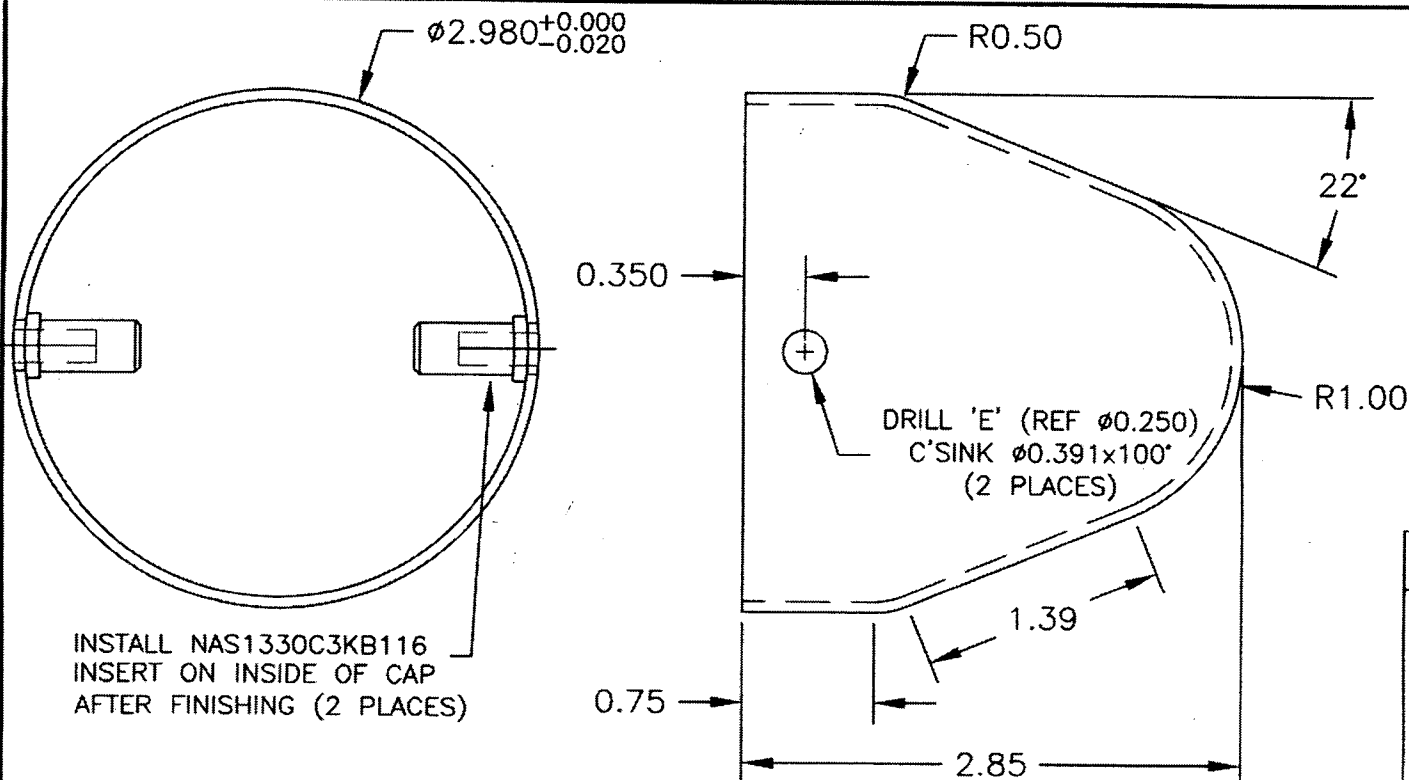
QA: N/C Closed: _____ Date: _____

DART

DESIGN	DS	DRAWN BY	CP	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.04.01	DRAWING NO.	D2646	REV. B
		TITLE	AFT CAP	SHEET 1 OF 1
				SCALE
				1:1
A	97.03.25	NEW ISSUE		
B	05.04.01	CHANGE TO CLOSED INSERTS		

REFERENCE ONLY

RELEASED
05-08-09



D2646 AFT CAP

- 1) MATERIAL: 1100-0 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NOTES OF REJECT:



1480 Manheim Pike
Lancaster Pa 17601

CERTIFICATION OF TEST RESULTS

SOLD TO

COPPER & BRASS SALES INC
22355 WEST ELEVEN MILE ROAD
SOUTHFIELD, MI 48034

SHIP TO

COPPER & BRASS SALES INC
6555 E. DAVIDSON
DETROIT, MI 48212

CERT NO 0000598687
DATE 10/26/2004
SKID NO 322296
SKID WGT 9,760
PAGE 1 OF 1

ORDER NO	LB4176	PO NO	C99792			MILL FINISH NOT ANODIZE QUALITY OUT: STANDARD MILL FINISH IN: STANDARD MILL FINISH NOT EMBOSSED
ITEM NO	1	PART NO	050393-8			
ALLOY	1100	TEMPER	O	FORM	COIL	
GAUGE	.06300	WIDTH	48.0000	LENGTH	0.0000	

LOT: 238066 COIL: B01 DROP: 440525

INGOT	SI	FE	CU	MN	MG	CR	NI	ZN	TI
4405252	0.11	0.42	0.08	0.02	0.002	0.001	0.004	0.003	0.02

HEAD ULTIMATE STRENGTH 12.2 KSI
TAIL ULTIMATE STRENGTH 12.6 KSI
HEAD YIELD STRENGTH (OFFSET = .2%) 4.9 KSI
TAIL YIELD STRENGTH (OFFSET = .2%) 5.6 KSI
HEAD ELONGATION (G.L. = 2 IN) 35.5 %
TAIL ELONGATION (G.L. = 2 IN) 33.5 %

CHEMICAL COMPOSITION ACCORDING TO ASTM E-1251-04
MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-02a

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:

ASME SB209 1100 O, AMS 4001H 1100 O,
ASTM B209-04 1100 O, AMS-QQ-A-250/1 1100 O

CERTIFICATION OF TEST RESULTS SHALL NOT BE REPRODUCED EXCEPT IN FULL
** END OF CERTIFICATION **

Handwritten:
Haw
Henry @ SHS
C/O
Sore @
LTS

This document certifies the material above has been tested in accordance with applicable specifications described herein and has met those requirements. The material is subject to terms and conditions on the Alcoa sales order agreement.

Authorized By:

JBFF FREADY, LAB SUPERVISOR



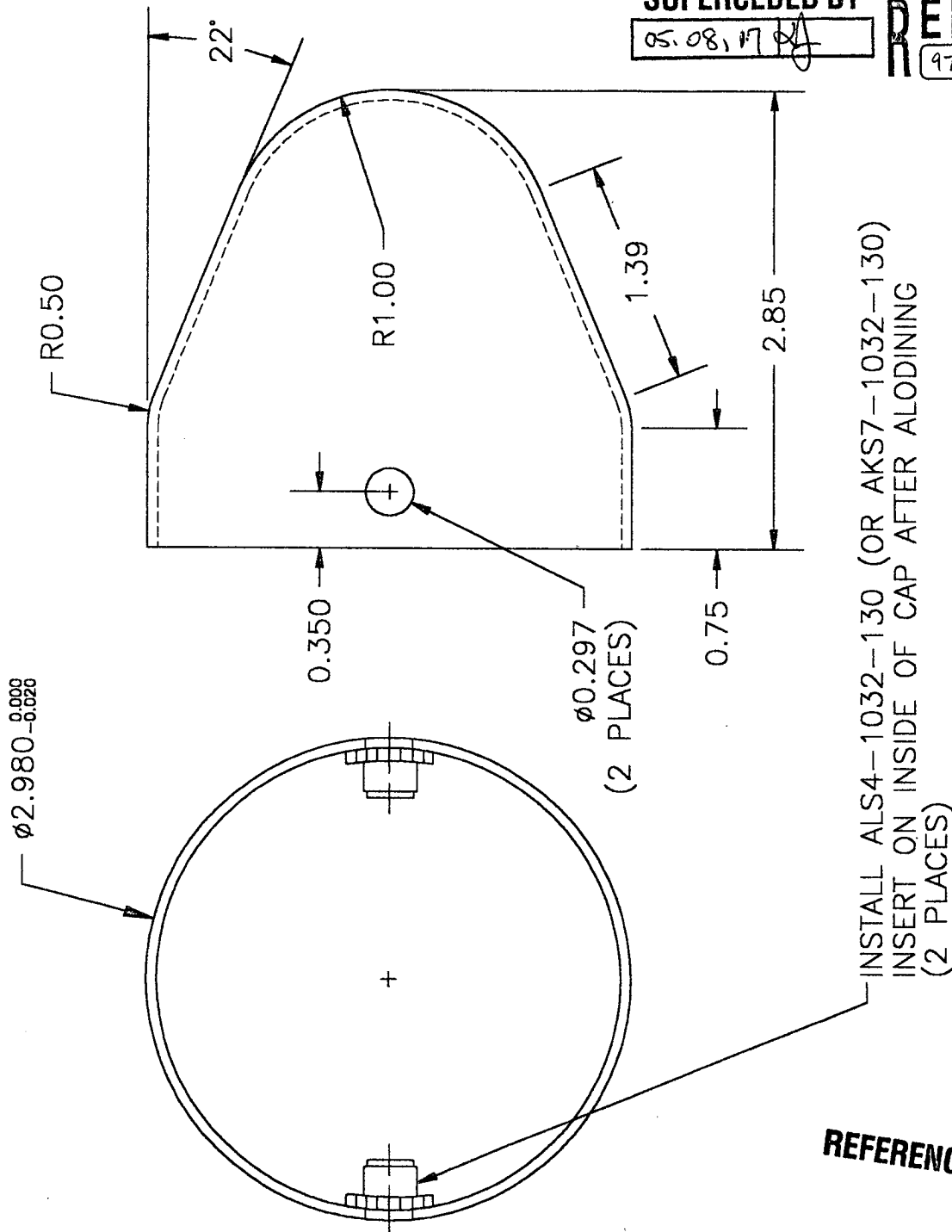


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2646	REV. A SHEET 1 OF 1
DATE 97:03:25	TITLE CAP		SCALE 1:1

SUPERCEDED BY

05.08.17 *[Signature]*

RELEASED
97/04/25 DS



MATERIAL: 1100-0 0.063 THICK (QQ-A-250/1)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

REFERENCE ONLY